

Ship July 6th or sooner

Work Order ID 60002

June 22, 2010 2:34:36 PM



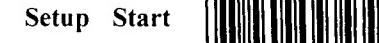
Page 1

Item ID: D4047-041

Accept



Setup



Start



Revision ID:

Item Name: Short Basket Lid Assembly

Stop



Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-06-22 Tooling:

Date:

Run



QC:

Date:

SPC (Y/N):

Date:

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4047

A

100

Weld per dwg A/R S.S. rod Batch: M108775 0.00



Large Fab

Large Fab

Memo

0.00

- 1- assemble ribs , weld as per dwg D4047
- 2- weld hinge and Mounting brackets as per dwg D4047
- ***inspect before welding mesh***
- 3- tack weld mesh on basket as per dwg D4047
- 4- weld label plate

① PD 10-06-23

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

JG 10-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

120



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

51010101

40

0.00

Memo

130



Powdercoat

Powder Coating

Black

White Gloss (Ref:4.3.5.2) per QSI005 4.3-Steel

PRESSURE WASH

Memo

0.00

DBL 10-7-5

PO.

1- Plug holes prior to

M112588.

1ST COAT:

START TIME: 10:00 320°

OVEN TEMPERATURE:

FINISH TIME: 10:30

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

N/A smooth

DBL 10-7-5

J

W/O:		4047-001	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-7-5	120	ADD SEQUENCE FOR PRESSURE WASH	BL	10-7-5		1007-06	1007-06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

135



HandFinish

Wing Walk as per dwg QSI005 4.4 Batch M114432 0.00

10/07/05

Hand Finishing

Memo

0.00

Mask label plate and Wing Walk and Spray Paint black as per Dwg D4047 and
QSI 005 4.4

140



QC3- Inspect Part Finish

0.00

QC

Quality Control

Memo

0.00

EBo/07/05 ①

150



Identify as per dwg & Stock Location: G-A 0.00

Packaging

Packaging

Memo

0.00

G-A
W/0 60000

EBo/07/05 C

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Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

JOC76

MF

10-7-6

W/O:		WORK ORDER CHANGES					
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Picklist Print

June 22, 2010 2:34:35 PM

Page 1 /2

Work Order ID: 60002



Parent Item: D4047-041



Parent Item Name: Short Basket Lid Assembly

Start Date: 6/22/10

Required Date: 7/02/10

Comments: IPP RevA: new issue DD 10.01.12 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581 		Manufactured	No			100	Each	41.0000		2			

Mounting Bracket

Location	Loc Qty	Loc Code
ST	15	
59121	15	
WA	26	(2)
46086	2	
51745	2	
57185	1	
59265	21	

D4016-3



Hinge Half, Lid

Location	Loc Qty	Loc Code
ST116	1	
58243	1	
WA	12	
58737	6	
59744	6	(3)

D4021-3



Data Plate

Location	Loc Qty	Loc Code
WA	4	
56050	1	
59054	3	(1)

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Picklist Print

June 22, 2010 2:34:35 PM

Page 2 / 2

Work Order ID: 60002



Parent Item: D4047-041



Parent Item Name: Short Basket Lid Assembly

Start Date: 6/22/10

Required Date: 7/02/10

Start Qty: 1.00

Required Qty: 1.00

D4046-7



Manufactured No

100 Each 0.0000

1

1

b60025 → ① PD 10.06.26

Mesh Lid

D4047-043



Manufactured No

100 Each 0.0000

2

2

b60026 → ② PD 10.06.25

Rib Assembly

D4047-1



Manufactured No

100 Each 0.0000

2

2

b60027 → ② PD 10.06.25

Rib

D4047-5



Manufactured No

100 Each 0.0000

2

2

b60028 → ② PD 10.06.25

Rib

D4047-7



Manufactured No

100 Each 0.0000

6

6

b60029 → ⑥ PD 10.06.25

Rib

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

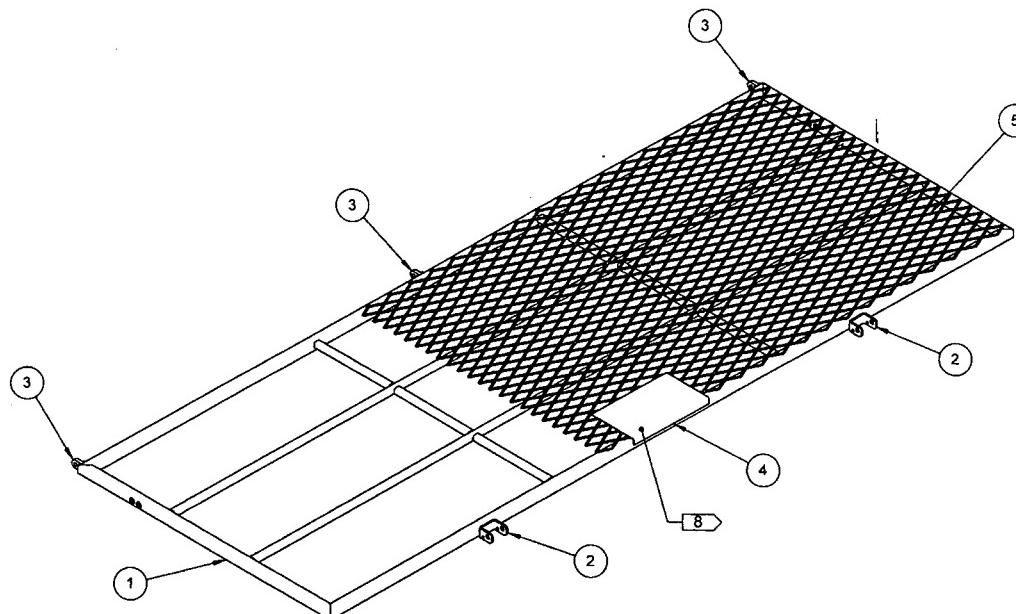
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4047-041	SHORT BASKET LID ASSY
1	1	D4047-101	LID FRAME ASSY
2	2	D2581	MOUNTING BRACKET
3	3	D4016-3	HINGE HALF, LID
4	1	D4021-3	LABEL PLATE
5	1	D4046-7	MESH



D4047-041 SHORT BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.17 lbs APPROX
- 8) APPL BLACK ANTI-SKID PAINT TO TOP SURFACE OF MESH, EXCEPT ON D4021-3 LABEL PLATE
PER DART QSI 005 4.4

SHOP CUP
RETURN TO:
ENGINEERING
UNCONTROLLED DRAWING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK OR USE
NO. 60002

BB/10-6-22

RELEASED
2010-02-16

A	NEW ISSUE		RF	10.01.29
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>RR</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>RR</i>	D4047	SHEET 1 OF 6	
APPROVED	<i>RR</i>	TITLE	SCALE	
DE APPR.	<i>RR</i>	SHORT BASKET LID ASSY	NTS	
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8 7 6 5 4 3 2 1

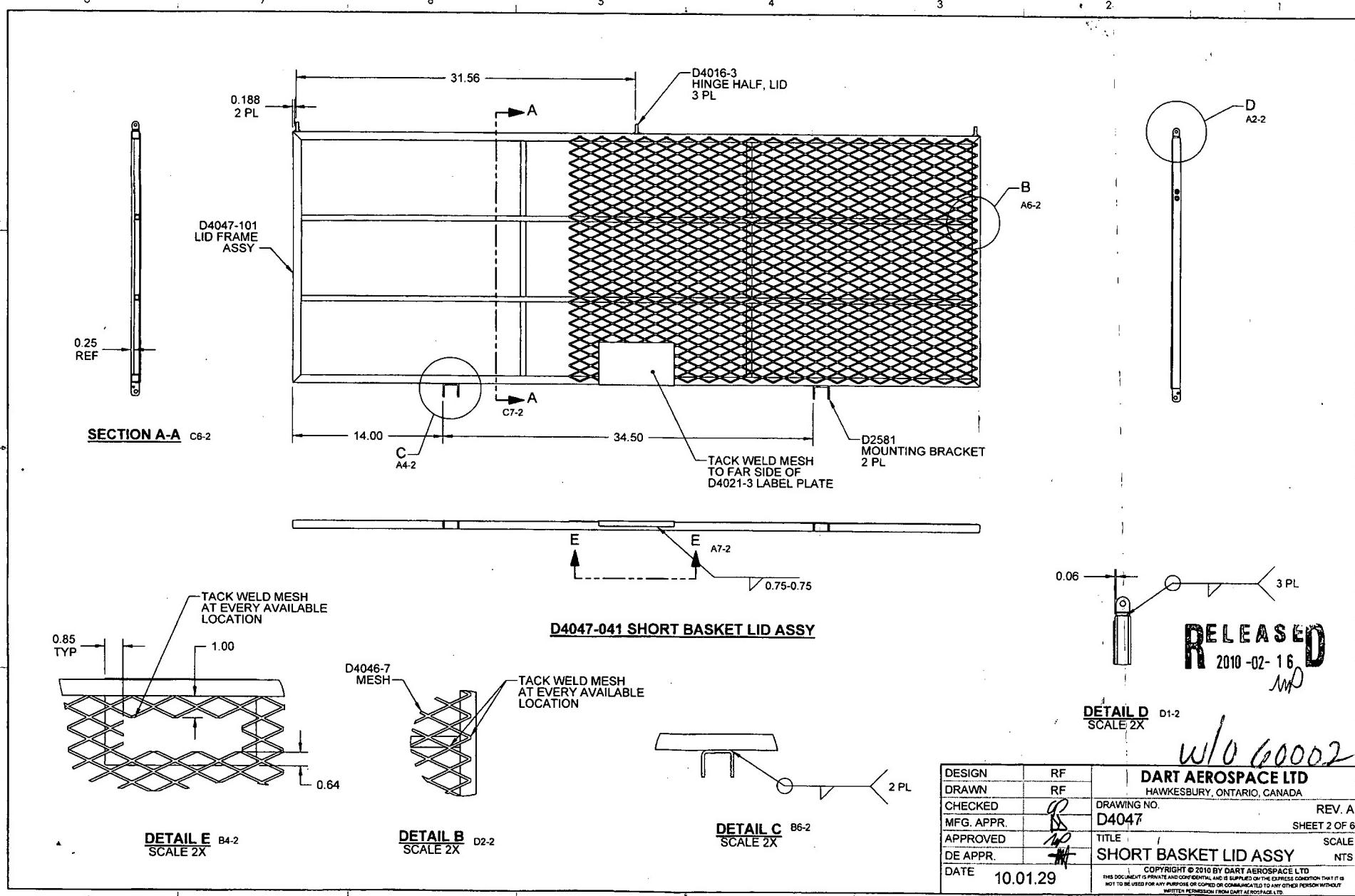
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



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NOTE: Date & initial all entries

8

7

6

5

4

3

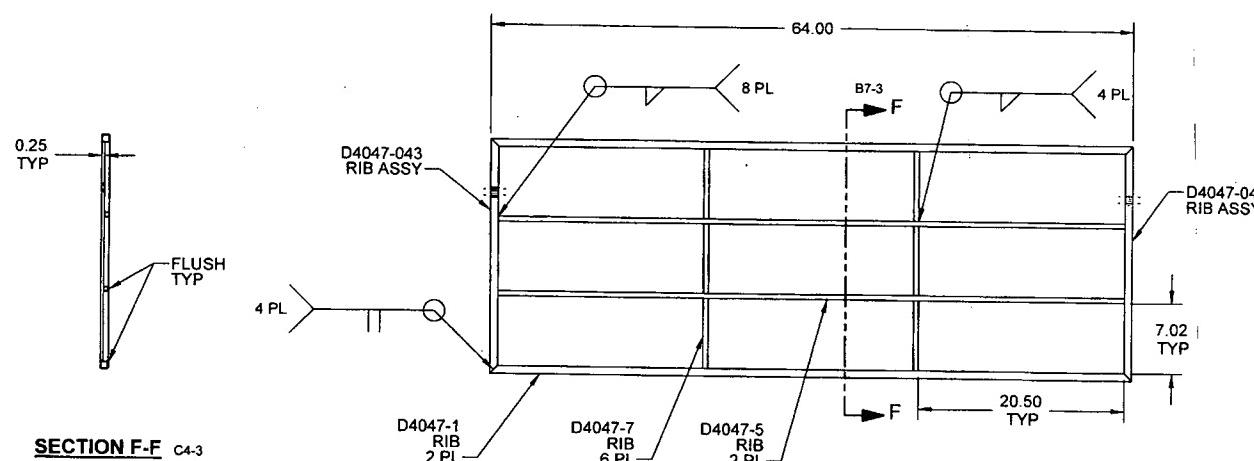
2

1

D

D

ITEM	QTY -101	P/N	DESCRIPTION
X		D4047-101	LID FRAME ASSY
1	2	D4047-043	RIB ASSEMBLY
2	2	D4047-1	RIB
3	2	D4047-5	RIB
4	6	D4047-7	RIB



D4047-101 LID FRAME ASSY

RELEASED
2010-02-16
MJ

wb 40002

DESIGN:	RF	DART AEROSPACE LTD	
DRAWN:	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED:	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D4047	SHEET 3 OF 6
APPROVED:	<i>JP</i>	TITLE:	SCALE
DE APPR.	<i>AS</i>	SHORT BASKET LID ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 10.33 lbs
- 8) WELD PER DART QSI 004

8 1 7 1 6 1 5 1 4 1 3 1 2 1 1

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D4047-043	RIB ASSEMBLY
1	1	D4047-3	RIB
2	2	D4021-9	BUSHING

D

D

C

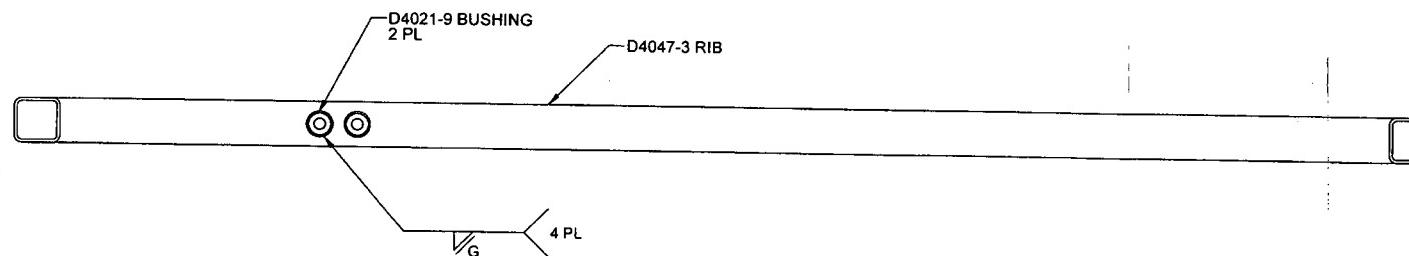
C

B

B

A

A



D4047-043 RIB ASSEMBLY

RELEASED
2010-02-16
MP

wb 60002

DESIGN	RF	DART AEROSPACE LTD	
DRAVN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RP	DRAWING NO.	REV. A
MFG. APPR.	RS	D4047	SHEET 4 OF 6
APPROVED	RP	TITLE	SCALE
DE APPR.	RP	SHORT BASKET LID ASSY	NTS
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8 7 6 5 4 3 2 1

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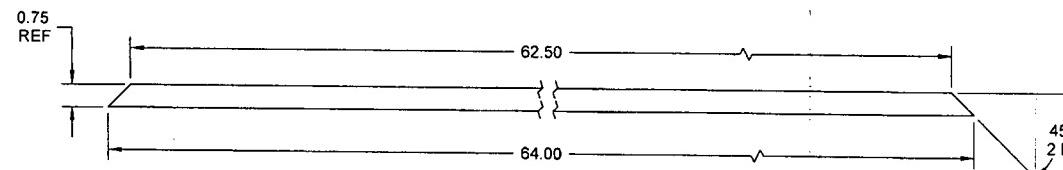
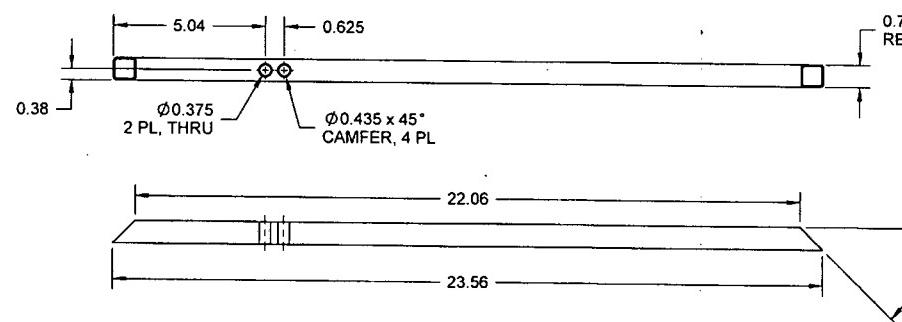
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8 7 6 5 4 3 2 1

**D4047-1 RIB****D4047-3 RIB****NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-1: 2.63 lbs
D4047-3: 0.84 lbs

8 7 6 5 4 3 2 1

RELEASED
 2010-02-16
MP

DESIGN	RF	
DRAWN	RF	
CHECKED	<i>QD</i>	
MFG. APPR.	<i>DS</i>	
APPROVED	<i>MP</i>	
DE APPR.	<i>MP</i>	
DATE	10.01.29	SCALE NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4047 REV. A
SHEET 5 OF 6

TITLE: SHORT BASKET LID ASSY

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W/O:		WORK ORDER CHANGES						
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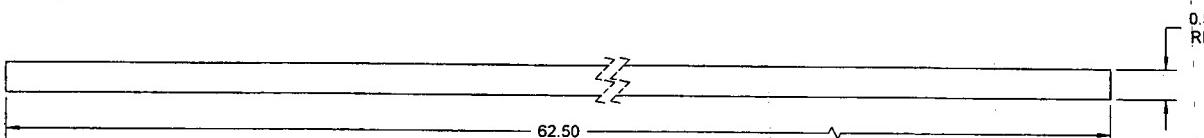
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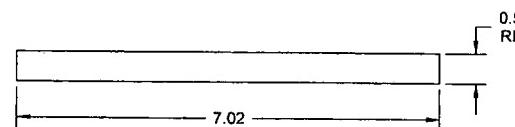
8 7 6 5 4 3 2 1

D

D



D4047-5 RIB



D4047-7 RIB

RELEASED
2010-02-16
W

W660002

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4047-5: 1.44 lbs
D4047-7: 0.16 lbs

8 7 6 5 4 3 2 1

A

A

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	Q	
MFG. APPR.	N	DRAWING NO. REV. A
APPROVED	M	D4047 SHEET 6 OF 6
DE APPR.	N	TITLE
DATE	10.01.29	SCALE
		NTS

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